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In the claims:

1. (Currently Amended) A rotary die apparatus for use with a first rotary die having a first axis of rotation and a second rotary die having a second axis of rotation parallel to the first axis of rotation comprising:

a base;

a plurality of elongate columns, each column having a first end and a second end defining a first axis of movement along a length thereof, the first end of each column [removably] mounted to the base in spaced relationship to one another;

at least one cross member positioned transverse to the second axis of rotation, the entire cross member is moveably engaged with respect to at least two of the plurality of columns for movement along the first axis of movement;

at least one first modular die support [removably] mounted to the base in spaced relation to the columns in rolling engagement with the first rotary die; and

at least one second modular die support [removably] mounted to the cross member in spaced relation to the columns in rolling engagement with the second rotary die[.]; [and

at least one die having an axis of rotation, the die positioned between the base and the cross member in rolling engagement with at least one of the first and the second modular die supports.]

2. (cancelled)

3. (Currently Amended) The apparatus of claim [2] 1 wherein the

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first die is in rolling engagement with the second die.

4. (Original) The apparatus of claim 3 wherein the first rotary die further comprises a first end surface and an opposing second end surface, the first die having a radially raised flange adjacent to at least one of the first and the second end surfaces.

5. (Original) The apparatus of claim 4 wherein the raised flange operably engages the first modular die support to limit linear translation of the first die along the first axis of rotation.

6. (Original) The apparatus of claim 4 wherein the raised flange operably engages the second die to limit linear translation of the second die along the second axis of rotation.

7. (Original) The apparatus of claim 1 wherein the cross member further comprises a first cross member and a second cross member, the first and second cross members positioned on opposing columns in spaced relationship with respect to one another.

8. (Original) The apparatus of claim 1 further comprising a pressure member operably engaged with the cross member for selectively adjusting the position of the cross member along the first axis of movement.

9. (Currently Amended) The apparatus of claim 1 wherein [at least one of] the first and the second modular die supports each further comprise a first bearing and a second bearing positioned in opposing relation along the axis of rotation, each bearing having at least two rollers having axes of rotation substantially parallel to one another and angularly spaced from one another from the axis of rotation.

10. (Currently Amended) The apparatus of claim 1 wherein the first rotary die and the second rotary die each further comprise[s] a first end surface and an opposing second end surface, [the] each die having an elongate journal extending from [at least one of] the first and second end surfaces along the axis of rotation; and

[at least one of] the first and second modular die supports each further comprising a pair of opposing cylindrical roller bearings positioned along the axis of rotation, [the] each cylindrical roller bearing operably engaged with one of the journals permitting free rotation of the die about the axis of rotation.

11. (Original) The apparatus of claim 10 further comprising at least one spacer positioned between the first and the second modular die supports.

12. (Currently Amended) A rotary die apparatus comprising:
a frame having a base, a plurality of elongate circular columns having a first end and a second end defining a first axis of movement along a length thereof, the first ends of the columns removably mounted to the base and the second ends of the

columns removably mounted to a cover, at least one cross member, the cross member positioned transverse to a second rotary die having a second axis of rotation, the entire cross member is moveably engaged with respect to at least two of the plurality of circular columns for movement along the first axis;

a first rotary die having a first axis of rotation, the first die having a first end surface and an opposing second end surface and at least one raised radial flange adjacent at least one of the first and second end surfaces;

a second rotary die having a second axis of rotation positioned in substantially parallel alignment with the first axis of rotation and in rolling engagement with the first die, the second die in operable engagement with the radial flange of the first die to limit linear translation of the second die along the second axis of rotation;

a first modular die support removably mounted to the base in spaced relation to the columns, the first die support having a first bearing member and a second bearing member separated from the first bearing member along the first axis of rotation, the first and second bearing members having at least two rollers in rolling engagement with the first rotary die having axes of rotations substantially parallel to one another and angularly spaced from one another from the first axis of rotation, at least one of the first and second bearing members in operable engagement with the raised radial flange to limit movement of a first die along the first axis of rotation; and

a second modular die support removably mounted to the cross member in spaced relation to the columns, the second die support having a first bearing and a second bearing member separated from the first bearing member along the second axis of rotation, the first and second bearing members having at least two rollers in rolling

engagement with the second rotary die having axes of rotation substantially parallel to one another and angularly spaced from one another from the second axis of rotation.

13. (Currently Amended) An improved rotary die apparatus for use with a first rotary die having a first axis of rotation and a second rotary die having a second axis of rotation parallel to the first axis of rotation having a base, [a plurality of elongate columns extending from the base,] a cover opposite the base, [engaged with the columns,] a pair of opposing cross members positioned transverse to the second axis of rotation wherein the entire cross members are moveable between the base and the cover, and a pressure member operably engaged with the cover and the cross members [for selectively positioning the cross member on the columns,] the improvement comprising:

four elongate rods having a first end mounted to the base in parallel and spaced relation to one another and a second end mounted to the cover defining a length, the rods having a uniform cross section along the length between the base and the cover;

a first modular die support having a first bearing and a second bearing positioned in opposing relation along the first axis of rotation, each bearing [removably] mounted on the base in spaced relation to the rods, each bearing having at least two rollers having axes of rotation substantially parallel to one another and angularly spaced from one another, the bearing rollers are positioned in rolling engagement with [a] the first rotary die permitting free rotation of the first rotary die about [a] the first axis of rotation; and

a second modular die support [removably] having a first bearing and a second bearing positioned in opposing relation along the second axis of rotation, each

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bearing mounted to one of the cross members in spaced relation to the columns in rolling engagement with the second rotary die permitting free rotation of the second rotary die about [a] the second axis of rotation.

14. (Original) The apparatus of claim 13 wherein the first die further comprises:

a raised radial flange adjacent at least one of a first and a second opposing end of the first die, the radial flange in operable engagement with the first modular die support to limit linear translation of the first die along the first axis of rotation.

15. (Original) The apparatus of claim 14 wherein the second die operably engages the radial flange of the first die to limit linear translation of the second die along the second axis of rotation.

16. (Currently Amended) The apparatus of claim 13 wherein [at least one of the first and] the second modular die support[s] bearings comprise at least two rollers having axes of rotation substantially parallel to one another and angularly spaced from one another.

17. (Currently Amended) The apparatus of claim 13 wherein each of the first and the second bearings [at least one of the first and] of the second modular die support[s] further comprise[s] [at least one] a cylindrical roller bearing for rolling

engagement with a journal on [at least one of the first and] the second die[s].

Claims 18-35 (cancelled).

36. (Previously added) The rotary die apparatus of claim 1 wherein the plurality of columns comprise four columns.

37. (Currently Amended) The rotary die apparatus of claim 1 wherein the elongate columns are uniform and circular in cross section along the length.

38. (Previously added) The rotary die apparatus of claim 12 wherein the plurality of columns comprise four columns.

39. (Previously added) The rotary die apparatus of claim 12 wherein the elongate columns are uniform in cross section along the length.

40. (Currently Amended) A rotary die module for use with a first rotary die having a first axis of rotation and a second opposing rotary die having a second axis of rotation, the rotary die module comprising:

a base;

[a plurality of] four parallel elongate [columns] rods having a first end and a second end defining a first axis of movement along a length thereof, the first ends of the [columns] rods [removably] mounted to the base in opposing and spaced relation

to one another, the second ends [removably] mounted to a cover, the rods having a uniform cross section along the length between the cover and the base;

[at least one cross member] a pair of opposing cross members positioned on opposing rods transverse to the second axis of rotation, each cross member is movably engaged on the opposing rods [with respect to at least two of the plurality of columns] for movement of the entire cross member along the first axis of movement;

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a first modular die support having a first bearing and a second bearing positioned in opposing relation along the first axis of rotation, each bearing having at least two rollers having axes of rotation substantially parallel to one another and angularly spaced from one another, each bearing is [removably] attached to the base in spaced relation to the columns and adapted to receive and rotatably engage [a] the first rotary die;

a second modular die support having a first bearing and a second bearing positioned in opposing relation along the second axis of rotation, each bearing having at least two rollers having axes of rotation substantially parallel to one another and angularly spaced from one another, each bearing is [removably] attached to one of the cross members in spaced relation to the rods, the second modular die support adapted to receive and rotatably engage the second rotary die; and

a pressure member engaged with the cover and the cross members for controlling movement of the second modular die support along the first axis of movement.

Claims 41-45 (cancelled).